



Dart Aerospace Ltd.
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Tel (613) 632-5200

D350-591-312

Job Sheet 173052



Part No: D350-591-312

Job Qty: 5 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/23/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	3/22/18		0.00	0.00	Start Up Large Fab-4		SL
110	Large Fab	5 pcs	3/22/18		0.00	5.00	Large Fab 2		SL
120	QC	5 pcs	3/22/18		0.00	0.00	QC9		PD 18-3-14
130	QC	5 pcs	3/22/18		0.00	0.00	QC5		PD 18-3-14
140	HandFinish	5 pcs	3/22/18		0.00	0.94	HandFinish1		SA 18-3-14
150	QC	5 pcs	3/22/18		0.00	0.00	QC7-2		CPC
180	Large Fab	5 pcs	3/22/18		0.00	5.00	Large Fab 2		QDA
190	QC	5 pcs	3/22/18		0.00	0.00	QC10		38 JAS
200	QC	5 pcs	3/22/18		0.00	0.00	QC5		1-89 38
210	HandFinish	5 pcs	3/22/18		0.00	0.94	HandFinish1		SA 18-01-04
220	Powdercoat	5 pcs	3/22/18		0.00	1.49	Powdercoat1		BL 18-4-5
230	HandFinish	5 pcs	3/23/18		0.00	0.94	HandFinish3		BE 18-04-06
240	QC	5 pcs	3/23/18		0.00	0.00	QC3	DAS	38
250	Packaging	5 pcs	3/23/18		0.00	0.00	Packaging1-3	6	APR 10 2018
260	QC	5 pcs	3/23/18		0.00	0.00	QC4	9-89	SMB
265	DC	5 pcs	3/23/18		0.00	0.00	DC		
270	Packaging	5 pcs	3/23/18		0.00	0.00	Packaging3-1		SMB
280	QC21-FG	5 Ea	3/23/18		0.00	0.00	QC21		APR 13 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138673 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 3:40 OVEN TEMPERATURE: 320 FINISH TIME: 4:10

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

wing walk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (2 ea)	90-Start up Operation	S047606
D3219-1	Plate	10 Ea (2 ea)	90-Start up Operation	S047627
D3272-1	Step	5 Ea (1 ea)	90-Start up Operation	S048819
D3065-041	Step Leg Assembly	5 Ea (1 ea)	180-Large Fab	S053783
D3066-1	Spacer	10 Ea (2 ea)	180-Large Fab	S051946
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab	S041174
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging	S017087
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging	S045860
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging	S041766
D2230-3	Mounting Lug	20 Ea (4 ea)	250-Packaging	S057382
D2618	Bushing	10 Ea (2 ea)	250-Packaging	S043411
D2856-400-700	Abrasion Strip 4" Wide (Per Foot)	6 Ea (1.2 ea)	250-Packaging	S057400
D3235-1	Mounting Lug	10 Ea (2 ea)	250-Packaging	S049171
D3278-041	Support Assembly	5 Ea (1 ea)	250-Packaging	S053030
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging	S038767
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging	S040901
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging	S041167
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging	S015269
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging	S045895
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging	S039036

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	23	0
	D3219-1	10	44	0
	D3272-1	5	0	0
180-Large Fab	D3065-041	5	12	0
	D3066-1	10	30	0
	MS20600-AD4W4	80	1,841	0
250-Packaging	AN3-35A	10	122	0
	AN4-13A	40	467	0
	AN5-36A	10	148	0
	D2230-3	20	65	0
	D2618	10	234	0
	D2856-400	6	95	0
	D3235-1	10	14	0
	D3278-041	5	8	0
	MS21042L3	10	3,411	0
	MS21042L4	40	998	0
	MS21042L5	10	877	0
	NAS1149D0363J	20	3,425	0
	NAS1149D0463J	80	2,258	0
	NAS1149D0563J	20	1,330	0

Part Specifications

Specifications could not be found.

Plex 2/26/18 8:39 AM Dart.Gagnon.Michelle



Container No: S049373



Part: D350-591-312

Job No: 173052

Serial No/Batch: S049373

Revision:

Inspector:

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Date: 03/08/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002378	S059726	AN3-35A	Bolt	s017089	ST348	10
002378	S059725	AN4-13A	Bolt	s045860	ST344	40
002378	S059724	AN5-36A	Bolt	s041116	ST336	10
002378	S059717	D2230-3	Mounting Lug	S051382	ST521	20
002378	S059728	D2618	Bushing	s043411	ST008	10
002378	S059727	D2856-400-720	Abrasion Strip 4" X 7.20"	s051490	ST418	10
002378	S059731	D3235-1	Mounting Lug	S049171	ST522	10
002378	S059732	D3278-041	Support Assembly	S053036	ST522	5
002378	S059723	MS21042L3	Nut	s038764	ST303	10
002378	S059722	MS21042L4	Nut	s045901	ST303	40
002378	S059721	MS21042L5	Nut	s041167	ST303	10
002378	S059720	NAS1149D0363J	Washer	s015269	ST263	20
002378	S059719	NAS1149D0463J	Washer	s045845	ST263	80
002378	S059718	NAS1149D0563J	Washer	s039036	ST263	20

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/10/18 2:43 PM dart.quirion.sonia

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hell-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hell-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hell-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hell-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hell-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hell-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.